

Work Order ID: 55957



Page 1

February 8, 2010 11:40:06 AM

Item ID: D4055-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Aft End

Start Date: 2/08/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4055

Rev A

100

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: 11330
Purchase part as per Dwg D4055
Possible Supplier: GFI
Material release note required

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

120

QC6- Inspect dimensions to drawing

0.00



QC

8/10/10 to present only
Memo

0.00

Quality Control

Pho → [Signature]
PT 10-2-08
(3)

2/10/3/4 (3)

Rev A - doesn't match P.O.
8/10/10/22

QC APPROVAL

PRELIMINARY ISSUE

W/O: 55951

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/1/22		PA1 to "Rev A" has differences. NO Ø180" (20.090) holes in the corners of the parts.					S 10/1/22

Part No: D4055-3 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Pro Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 55951

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		Scrap parts. Parts are not the same as part to Rev A.		- Restoring Parts.				S 10/1/22

NOTE: Date & initial all entries

Work Order ID 55957

February 8, 2010 11:40:06 AM



Page 2

Item ID: D4055-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Aft End

Start Date: 2/08/10

Start Qty: 3.00



Cust Item ID:

Required Date: 2/22/10

Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location:

Prel.

0.00

Memo

Shelf.

0.00

Feb/10.04.13

③

N/A

10.03.08

Work Order ID 55957

February 8, 2010 11:40:07 AM



Page 3

Item ID: D4055-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Aft End

Start Date: 2/08/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

*Test A**10-11-14*
(3)

POSITIVE RECALL

EFFECTIVE 10-02-08 AUTH ll

RELEASED _____ DATE _____

Picklist Print

Page 1

February 8, 2010 11:40:05 AM

Work Order ID: 55957



Parent Item: D4055-3



Parent Item Name: Tank Aft End

Start Date: 2/08/10

Required Date: 2/22/10

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM

Start Qty: 3.00

Required Qty: 3.00

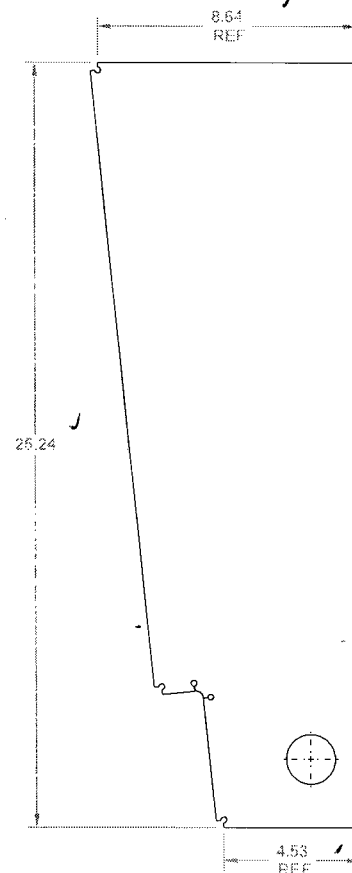
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4055-3P		Purchased	No			110	Each	0.0000	3.0000			



Tank Aft End

Wb
55957

RD.19
TYP
0.50
TYP



D4055-3 TANK AFT END

PRELIMINARY ISSUE

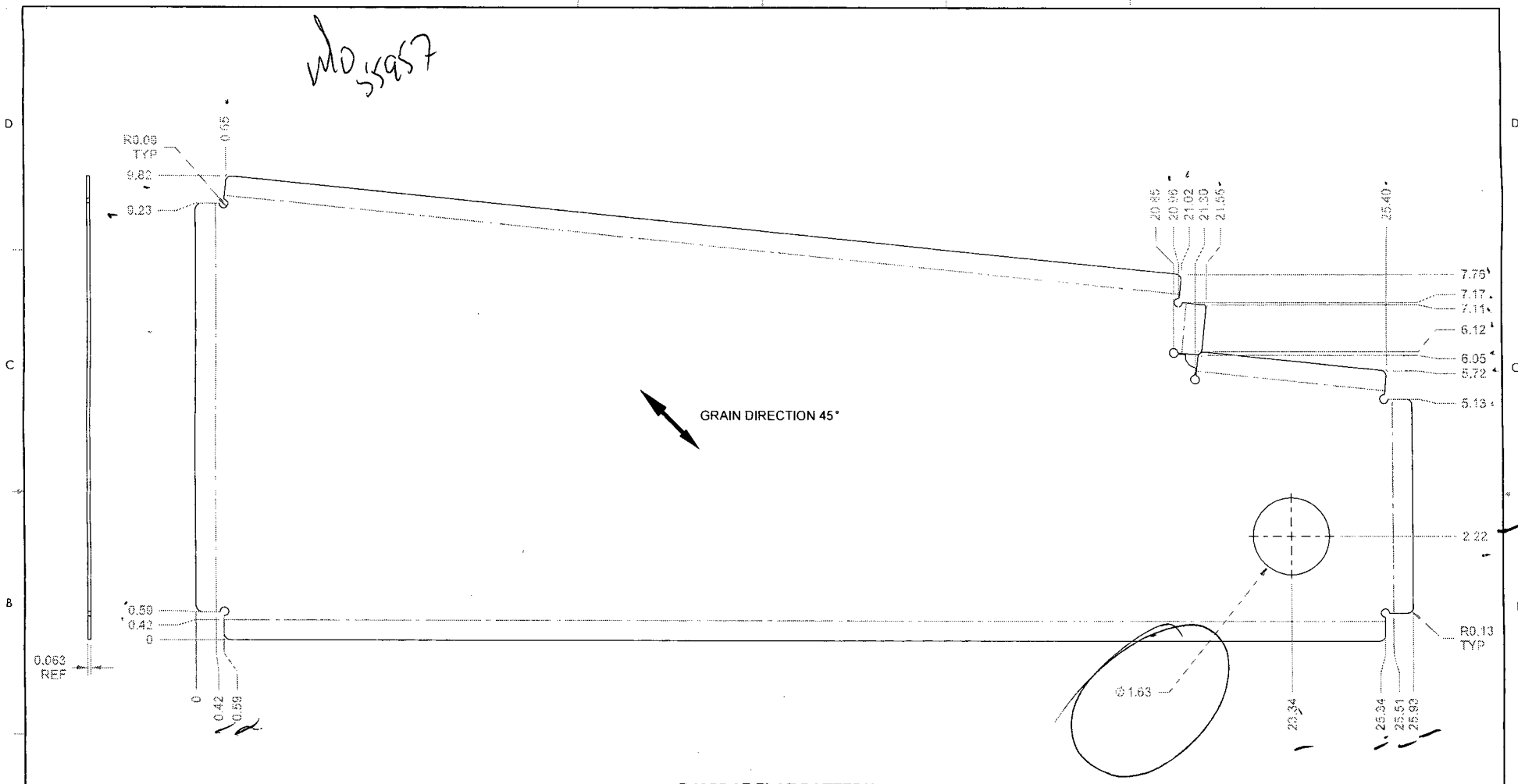
10.01.11

NOTES:

- 1) MATERIAL: MADE FROM D4055-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.30 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. PA1
APPROVED		SHEET 6 OF 15
DE APPR.		SCALE
DATE	10.01.11	1:8
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MO 5957



D4055-3F FLAT PATTERN

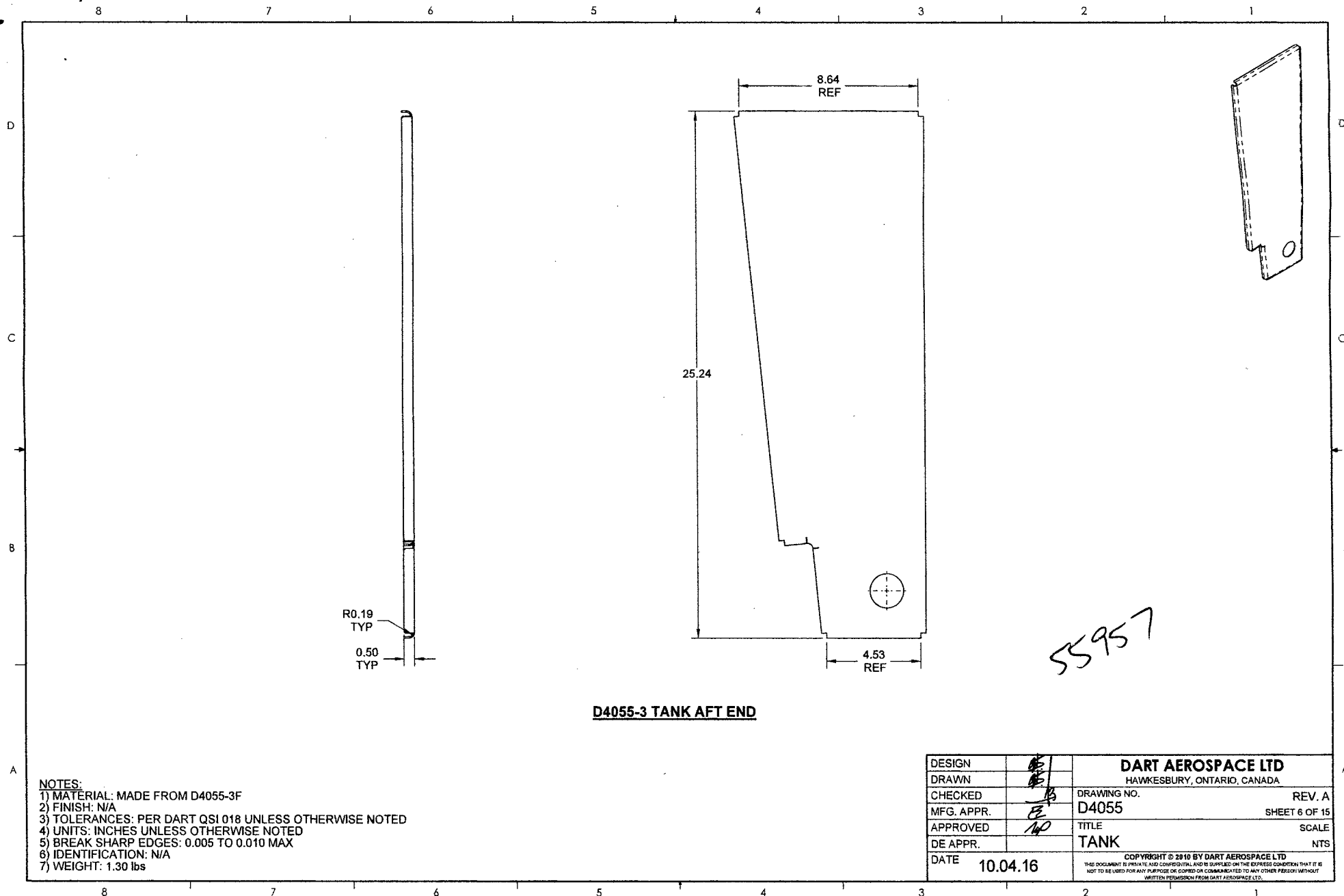
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.30 lbs

PRELIMINARY ISSUE

10.01.11

DESIGN		DART AEROSPACE LTD
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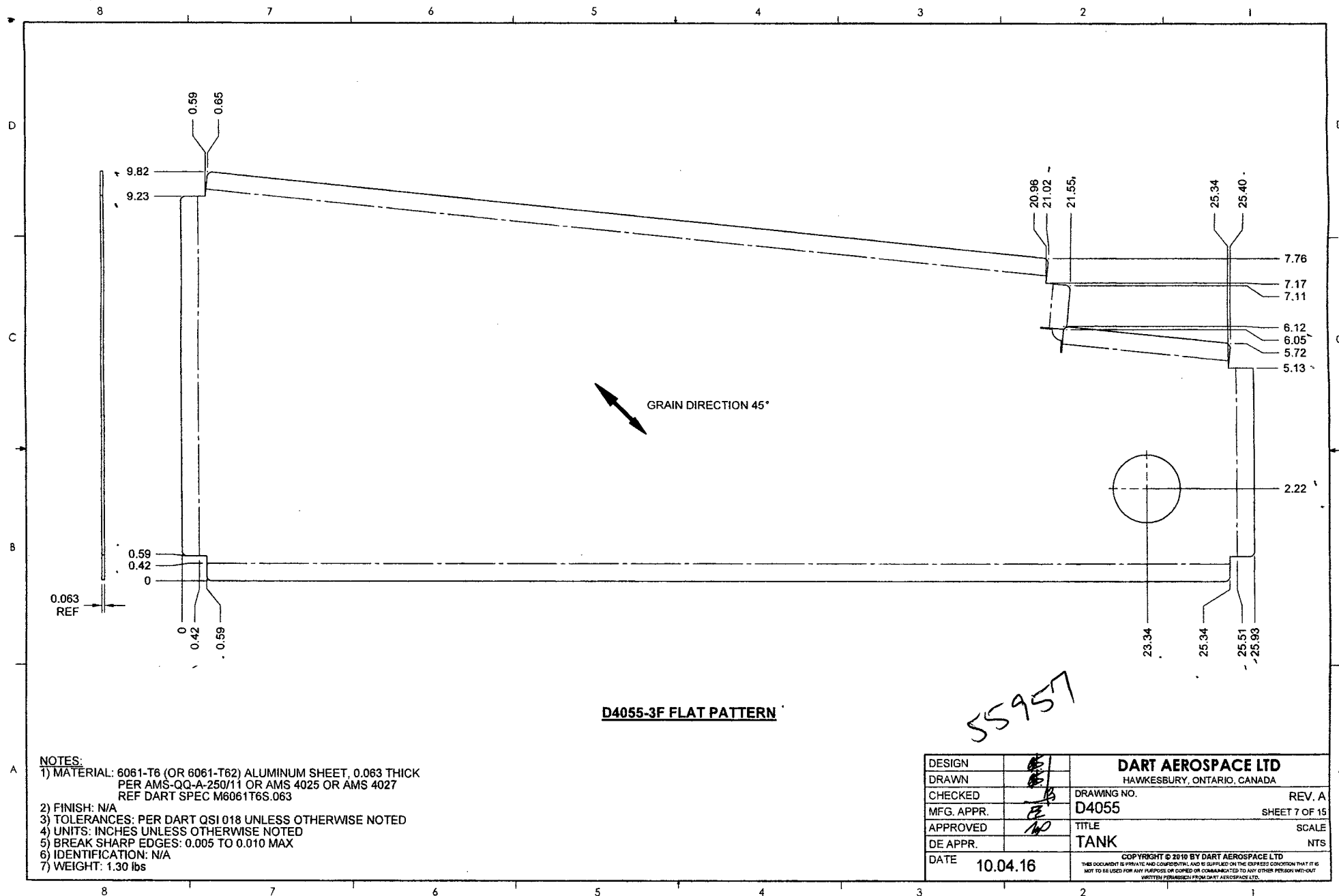


D4055-3 TANK AFT END

NOTES:

- 1) MATERIAL: MADE FROM D4055-3F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.30 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4055	SHEET 6 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	10.04.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	





180 AVENUE LABROSSE
POINT-CLAIRE, QC, CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON / SHIPPING MEMO NO.		PAGE
JR - DY	MO. - MO.	AN. - YR.			
02	03	10	0433553		1/1



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE		N° DE CONTRAT / JOB NO.	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR / SHIP VIA
DART GFI-0299		0210444	PO11330	

QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO.	DESCRIPTION
---------------------	------------------------	-------------

3 D4055-3P

TANK AFT END

CERTIFICATE OF CONFORMANCE REQ

MFG. JOB# J0210444-001 QTY 3

(1) BOX



REÇU PAR / RECEIVED BY

DATE

EXPÉDITEUR / SHIPPER

N° DE BON DE LIVRAISON / SHIPPING MEMO NO.



TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

S. 6/2/08

CERTIFICATE NO.	<u>1</u>	OUR JOB NO	<u>J0210444</u>	SHIPPING MEMO	<u>0433553</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>-</u>	<u>3 PCS</u>	<u>PO11330</u>	<u>D4055-3P</u>		<u>TANK AFT END</u>	<u>PA1</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>AL 6061-T6</u>		<u>SAMUEL / ALCOA INC</u>		<u>608951</u>		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>CONFORMS</u>
2	<u>REF. GFI MANUFACTURING JOB NUMBER J0210444-001 (3 PCS)</u>		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 03 MARCH 2010

G.F.I. Q.C. REP.

Patton Hord



SAMUEL

LES METAUX SPECIALISES SAMUEL
21525 CLARK-GRAHAM
BAIE D'URFE, QUEBEC, CANADA
H9X 3T5
(514) 457-3399 FAX (514) 457-9393

No 001591859



PAGE 1 DE/OF 1

TRANSPORTEUR/CARRIER NAME
ASTERO TRANSPORT

CAMION/TRUCK
099

NOM DE LA BRANCHE/SALES BRANCH NAME
SAMUEL & FILS & CIE(QUEBEC) L

DATED/EXP/DATE OF SHIPMENT
2/16/10

VENDU À/SOLD TO:

GFI, DIVISION DE THOMAS & BETTS LTEE
180 LABROSSE

POINTE-CLAIRE

QC

H9R1A1

(514) 630-4877

EXPÉDIÉ À/SHIP TO: TÂB: PPD

GFI INC.
180 LABROSSE

POINTE-CLAIRE

QC

H9R1A1

CA

(201009-00001)

N° COMMANDE
N° ITEM
000752-01

DESCRIPTION ET POIDS/DESCRIPTION AND WEIGHT

#Comm du client: 76423
4 PCS AL. SH. 6061 T6
.0630"x48"x144"

Cert/Test: FAX
174 LVR

QQA 250/11
#Pièce AS06348144QM

Description

Art

Pd ca

Qté

#Étiq

Vendeur Org

#Étiq mln

#À soul

4

192.000

174

Étiq princ

#Coul

764479

4947487

ALR

US

Total:

4

192.000

174

D654824 608951

Poids total:

#Total paquets:

1

174 LVR

Commentaires connaissance:

CERTIFICAT DE CONFORMITÉ
LE MATÉRIEL DÉTAILLÉ CI-DESSUS EST CERTIFIÉ
CONFORME AUX EXIGENCES DE VOTRE COMMANDE ET AUX
SPÉCIFICATIONS DES NORMES DU GRADE. SVP VOUS
RÉFÉREZ AUX CERTIFICATS CI-JOINTS. AUTORISÉ PAR:

Melissa Diamond
MÉLISSA DIAMOND
ADMINISTRATION

DATE 16/02/10



NIR: R-539477-1

PAR ☒ PORT PAYÉ/PREPAID ☐ PORT D'UN COLLECT
CHARGES
EXPÉDITEUR/DISPATCHER

INST. VOITURIER/DRIVER INSTRUCTIONS

VOITURIER/DRIVER

VALEUR (\$2,000/b max à moins d'avis contraire)
VALUATION (Max \$ 2,000/b unless otherwise stated)
VALUER DÉCLARÉE DE L'EXPÉDITION
DECLARED VALUE OF SHIPMENT
REÇU PAR/RECEIVED BY

1. ORIGINAL - NON NÉGOCIABLE (CE CONNAISSEMENT DOIT ÊTRE SIGNÉ PAR L'EXPÉDITEUR ET LE VOITURIER)

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Kenton P. Young
Quality Assurance Manager

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

1058276	0	Ship From:		RIVERDALE, IA.
Ship Date	B.L. No.	Invoice No.	Alcoa No.	Item
2009-10-15	4303234	00000	1000143904-6	Page 1
P.O. No./Govt Contract No.	Customer	Alcoa Item		
N22238 Ln#: 6	SAMUEL SON & CO LT G041110647R02			

Item Description
0.063 IN TK (+0.0000 -.0035) X 48.0 IN W (+.125 -.125) X 144.0 IN LN (+.15625 -.15625) (N) A/T 6061-T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE GUARANTEED. AMS4027 REV N EXC MRK ASME-SB-209 REV 07 EXC_MRK ASTMB209 REV 07 CMMPO25 REV S CMMPO19 REV D ((MARKED)) KRAFT PAPER INTERLEAVED MAX GROSS SKID WGT: 4500 LB QUAN TOL +/-30 % CQR 0222751 REV 02 CUST REQ 09-10-01 *** W/E 09-10-24 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl	Inspector Clock Numbers
1	764477	608951	4119	100	PC	:	27299 47004
2	764478	608951	3408	83	PC	:	27299 47004
3	764479	608951	4149	100	PC	:	27299 47004
			11676	283			

Notes for COR: 0222751.2
PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 ORIGINAL REVISION DATED
1997-08-01.
COR: 0222751.2

CQR: 0222751.2 -Specification Limits

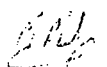
Temp	Dir	UTS	TYS	EL4D
T6	Long Transv.	KSI	KSI	PCT
	Max			
	Min	42.0	35.0	10


Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 6061	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15	
	Min	0.40		0.15		0.8	0.04					REMAIN

CERTIFIED INSPECTION REPORT

Alcoa Inc.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Per: 
Malcolm Murphy
Director of Manufacturing Davenport Works


Kerton P. Young
Quality Assurance Manager

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

1058276

Ship Date

0

B.L. No.

2009-10-15

4303234

Invoice No.

00000

Alcoa No. Item

1000143904-6

Page 2

DCE-43904-6

P.O. No./Govt Contract No.

N22238 Ln#: 6

Customer

Alcoa Item

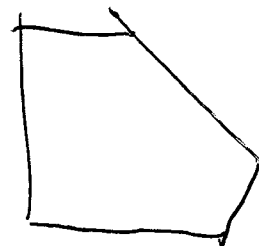
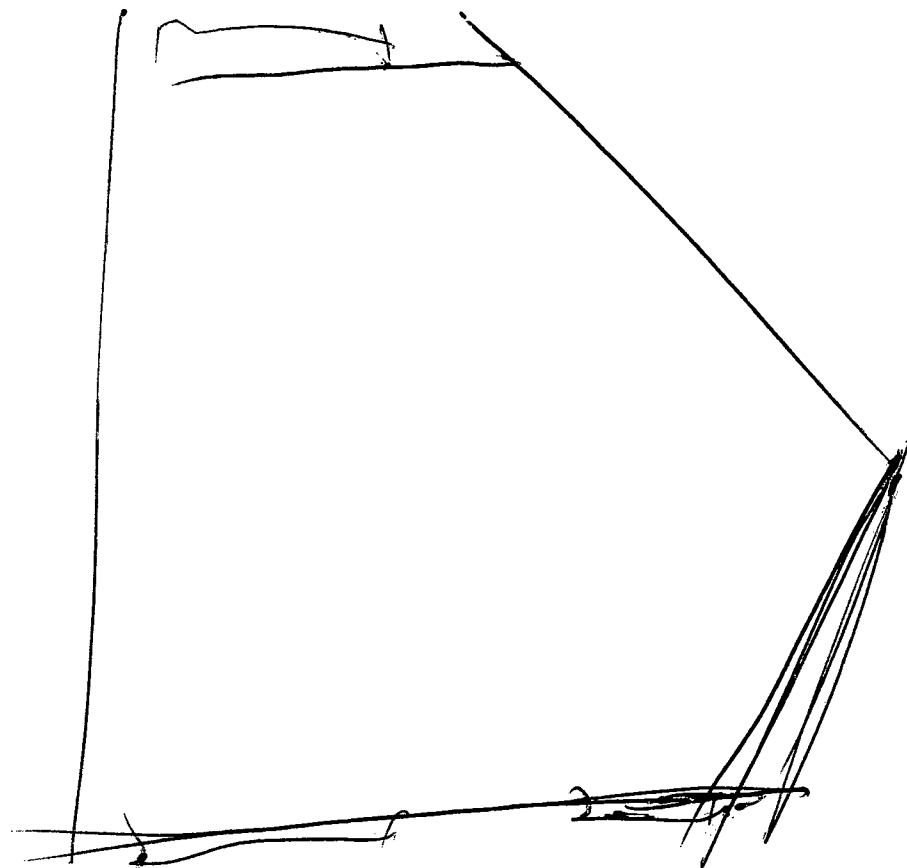
SAMUEL SON & CO LT G041110647R02

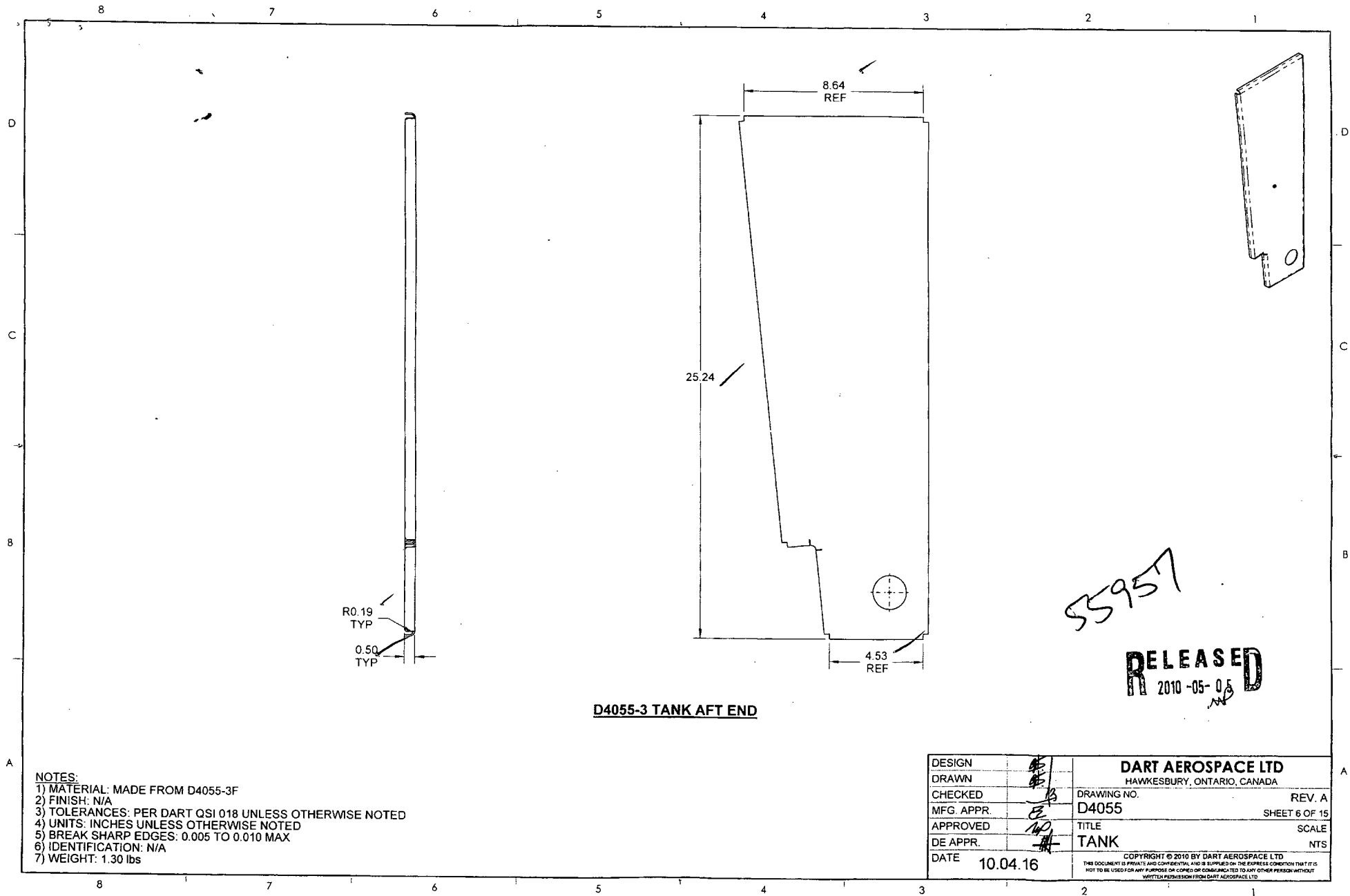
CQR: 0222751.2 -Specification Limits (cont.)
Lot: 608951 - Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No->	UTS	TYS	EL4D
T6	Long Transv.	Test	KSI	KSI	PCT
		2	50	44.8	10.9
			49.9	44.8	10.9

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H8054013	Actuals	0.66	0.5	0.26	0.06	0.9	0.19	0.05	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States





D4055-3 TANK AFT END

- NOTES:
- 1) MATERIAL: MADE FROM D4055-3F
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.30 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4055	SHEET 6 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	10.04.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

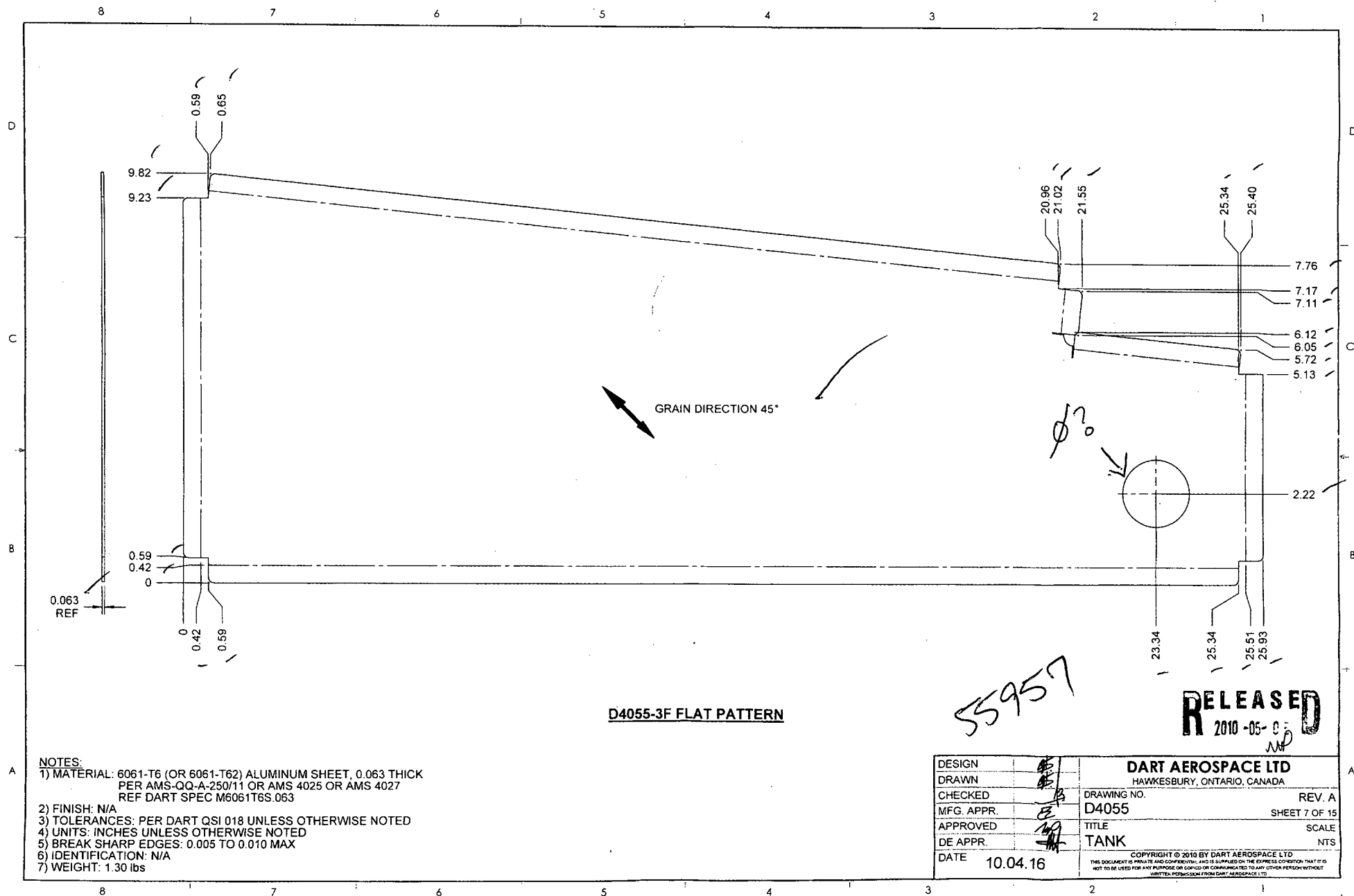
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



[illegible]